

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023252**Date Inspected:** 02-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding and heat straightening Bike Path Assemblies. ZPMC QC Yu Zhi Lai was present at this time of this observation and informed this QA inspector of the work that is in process and identified Shi Xu as the CWI. This QA inspector verified this information for the following location;

Weld- BK009A8-001-001, 002

WPS-B-T2312-TC-P4

Welder- 050038

2G/SMAW/PJP

Weld- BK009A2-001-176

WPS-B-T2231-ESAB

Welder- 057266

1F/FCAW

Heat Straightening

HSR1 (B) 10334

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BK010A-001-013~021

Bay 11

This QA inspector observed ZPMC in process of welding mislocated holes on Lift 6 sub-assembly. ZPMC CWI Guo Yan Fei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

CWR682

Weld- DPSA6-5

WPS-345-SMAW-IG(1F)Repair-Mislocated-Hole

Welder- 041271, 202354

1G/SMAW

The following digital picture illustrates Lift 6 sub-assembly mislocated hole repair.

Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening traveler rail. ZPMC CWI Chen Shi Gang was present at this time of this observation and informed this QA inspector of the work that is in process. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10282

3024TR1-001

Bay 5

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening traveler rail. ZPMC QC inspector Li Wei Lin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Tian Lei as the CWI. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10291

3023TR1-001

Heat Straightening

HSR1 (B) 10291

3025TR1-001

Bay 1

This QA inspector observed ZPMC in process of welding on Bike Path Handrail Assembly. ZPMC QC inspector Zhang Ya Xu was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhu Tian Shu as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

for the following location;

Weld- Bike Path Handrail Assembly

WPS-B-P-2112

Welder- 054452

2F/SMAW (Post to Base Plate)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
